

# इंटरनेट

# मानक

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IS 10-4 (1989): Plywood Tea-Chests: Part-4 Metal Fittings  
[CED 9: Timber and Timber Stores]



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IS 10 (Part 4) - 1989

REAFFIRMED

2008

*Indian Standard*

# PLYWOOD TEA-CHESTS-SPECIFICATION

PART 4 METAL FITTINGS

*( Fifth Revision )*

भारतीय मानक

प्लाईवुड चाय पेटीयां - विशिष्ट

भाग 4 धातु के फिटिंग्स

( पाँचवां पुनरीक्षण )

UDC 621'798'123 [ 674-419'32 : 663'95 ] : 621'88

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BUREAU OF INDIAN STANDARDS  
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG  
NEW DELHI 110002

May 1990

Price Group 1

**AMENDMENT NO. 1 AUGUST 1991  
TO  
IS 10 ( Part 4 ) : 1989 PLYWOOD TEA-CHESTS —  
SPECIFICATION  
PART 4 METAL FITTINGS  
( Fifth Revision )**

( Page 1, clause 4.1, line 1 ) — Delete the word 'nominal'.

( Page 2, Table 2, col 3 ) — Insert '2' against lot size of '3 001 to 10 000'.

( Page 2, clause A-3.1, line 3 ) — Insert the word 'failing' after the word 'fitting'.

( CED 33 )

## FOREWORD

This Indian Standard ( Part 4 ) ( Fifth Revision ) was adopted by the Bureau of Indian Standards on 21 December 1989, after the draft finalized by the Timber Stores Sectional Committee had been approved by the Civil Engineering Division Council.

This standard, covering provisions relating to metal fittings of plywood tea-chest, in its fourth revision ( 1976 ) was published as one of the following five parts:

Part 1 General

Part 2 Plywood

Part 3 Battens

Part 4 Metal fittings

Part 5 Assembly and packing

This fifth revision of Part 4 prescribes 'waste-waste quality' tinplate or terne plate as material for metal fittings. Only the minimum thickness of metal fittings has been specified instead of giving the range of thickness. Since the testing of dimensions of metal fittings is done on a set of 12 pieces, the definition of lot size has been modified accordingly.

In the formulation of this standard due weightage has been given to international co-ordination among the standards and practices prevailing in different countries in addition to relating it to the practices in the field in this country.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

# Indian Standard

## PLYWOOD TEA-CHESTS — SPECIFICATION

### PART 4 METAL FITTINGS

#### ( Fifth Revision )

#### 1 SCOPE

1.1 This standard (Part 4) covers dimensions and other requirements of metal fittings used in the assembly of plywood tea-chests.

#### 2 REFERENCES

2.1 The Indian Standard IS 4905 : 1968 'Methods for random sampling' is a necessary adjunct to this standard.

#### 3 MATERIAL

3.1 The metal fittings shall be manufactured from waste-waste quality tinplate or terne plate. The tinplate or terne plate shall have a clean smooth flat surface and shall be free from rust and serrated edges.

#### 4 DIMENSIONS AND TOLERANCES

##### 4.1 Thickness

The minimum nominal thickness of metal fittings for corner, top and bottom shall be 0.22 mm.

##### 4.2 Width

The width of metal fittings for corner, top and bottom shall be  $38 \begin{smallmatrix} +3 \\ -0 \end{smallmatrix}$  mm.

##### 4.3 Length

4.3.1 The length of 4 corners and 8 pieces for top and bottom for square and rectangular tea-chests of the sizes mentioned shall be as given in Table 1.

4.3.2 The 4 corner pieces shall be flat with beaded edges.

4.3.3 The 8 top and bottom pieces shall be with beaded edges, angled 90° and a 'V' notch in the centre; notch extending up to the fold. The position of notch shall be as indicated in Table 1.

4.3.4 For tea-chest of size 380 mm × 685 mm × 845 mm, used exclusively for packing instant tea, the length of fittings shall be as follows:

##### a) For corners

4 pieces flat with beaded edges and of length 844 mm.

##### b) For top and bottom

1) 4 pieces flat with beaded edges 686 mm.

2) 4 pieces flat with beaded edges of length 380 mm.

NOTE — Metal fittings with straight end shall be permitted for this size only.

#### 5 SAMPLING

5.1 The method of drawing representative samples of tea-chest fittings shall be as prescribed in Annex A.

#### 6 MARKING

6.1 Each fitting shall be marked with indication of the source of manufacture.

**Table 1 Length of Metal Fittings**  
(Clauses 4.3.1 and 4.3.3)

Sl No.	Size of Tea-Chest	Length		Position of V Notch
		Corners (4 pcs)	Top and Bottom (8 pcs)	
(1)	(2)	(3)	(4)	(5)
	mm	mm	mm	
i)	480 × 480 × 600	580	495	Middle
ii)	480 × 480 × 560	540	495	Middle
iii)	460 × 460 × 500	480	475	Middle
iv)	400 × 400 × 600	580	415	Middle
v)	400 × 400 × 500	480	415	Middle
vi)	400 × 400 × 450	430	415	Middle
vii)	400 × 500 × 600	580	465 × 4	At 207.5 mm from one end
			465 × 4	At 257.5 mm from one end
Tolerances		± 3 mm	± 3 mm	

## ANNEX A

### ( Clause 5.1 )

#### SAMPLING OF PLYWOOD TEA-CHEST FITTINGS

##### A-1 SAMPLING

###### A-1.1 Lot

In a consignment all the sets of metal fittings ( 4 corners and 8 top and bottom pieces ) for each size of tea-chest manufactured from the same material shall be grouped together to constitute a lot.

**A-1.2** Each lot shall be tested separately for determining its conformity to the requirements of the standard.

##### A-2 SCALE OF SAMPLING

**A-2.1** The number of fittings to be selected in the sample from a lot shall depend upon the size of the lot and shall be in accordance with col 1 and 2 of Table 2.

**A-2.2** The fittings for the samples shall be selected at random from the lot. For random selection of the fittings guidance may be obtained from IS 4905 : 1968.

**Table 2 Scale of Sampling and  
Criteria for Conformity**  
( Clauses A-2.1 and A-3.2 )

Lot Size	Sample Size	Permissible No. of Defectives
(1)	(2)	(3)
501 to 1 000	13	0
1 001 to 3 000	20	1
3 001 to 10 000	32	
10 001 to 35 000	50	3
35 001 and above	80	5

##### A-3 CRITERION FOR CONFORMITY

**A-3.1** All the fittings selected in the sample shall be visually examined and inspected for dimensions and tolerances. A fitting in one or more requirements shall be considered as defective.

**A-3.2** A lot shall be considered as having conforming to the requirements of this standard if the number of defective fittings as obtained in A-3.1 does not exceed the corresponding permissible number of defectives in col 3 of Table 2.



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Doc : No. CED 33 ( 4832 )

#### **Amendments Issued Since Publication**

Amend No.	Date of Issue	Text Affected

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